

Work Order ID 66840

Monday, February 28, 2011 12:44:34 PM



Page 1

Item ID: D4001-1

Accept



Setup Start



Revision ID:

Item Name: Fitting

Stop



Start Date: 2/28/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 3/4/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

M

Date: *11-02-28*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4001

A

100

0.00



Bandsaw

Memo

0.00

Jeaspa Bandsaw

cut blank 4.200" long

SL 11/03/03

(4)

110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MILL AS PER DWG AND FOLIO FA912

FOLIO REV: *AA*

DWG REV: *A*

DEBURR

SL 11/03/08

PTD-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4001-1 PAR #: _____ Fault Category: Machining NCR: Yes No DQA: 1 Date: 11/03/08
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 11/3/9 Date: 11/3/9

NCR: 66840		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/03/08	110	1 part flap broke in hole while tapping R.C. process	<u>[Signature]</u>	-scrap + replace <u>B107221</u>	<u>SL</u> 11/03/08	<u>and</u> 11/03/08	<u>[Signature]</u>	<u>[Signature]</u> 11-03-08

NOTE: Date & initial all entries

Work Order ID 66840

Monday, February 28, 2011 12:44:34 PM

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Item ID: D4001-1

Accept

Revision ID:

Item Name: Fitting

Start Date: 2/28/2011 Start Qty: 4.00

Required Date: 3/4/2011 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

- SL 11/03/08

Quality Control

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

aml 4/03/08

4 0

Quality Control

140

Identify as per dwg & Stock Location: 105

0.00



Packaging

Memo

0.00

4/13/08 (4)

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66840

Monday, February 28, 2011 12:44:34 PM

Page 3

Item ID: D4001-1

Accept

Revision ID:

Item Name: Fitting

Start Date: 2/28/2011 Start Qty: 4.00

Required Date: 3/4/2011 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/9 JF

MIF
11-03-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, February 28, 2011 12:44:44 PM

Page 1

Work Order ID: 66840

Parent Item: D4001-1

Parent Item Name: Fitting



Start Date: 2/28/2011

Required Date: 3/4/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPPP REV:A NEW ISSUE 10-02-22 JLM VERIFIED BY:EC IPP rev B
10.05.13 ecn10-562 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X04.00 0		Purchased	No			100	f	51.9007	0.3501	1.474105			



6061-T6 Bar 1.00 x 4.00



SL 11/03/03

Location	Loc Qty	Loc Code
MAT	12	
107221	0	
116808	12	
MAT03	39.9007	
107221	38.8685	1.5
114352	1.0322	

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. *66846*

2811-02-28

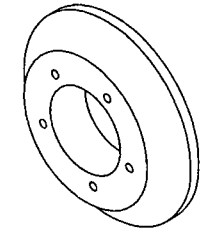
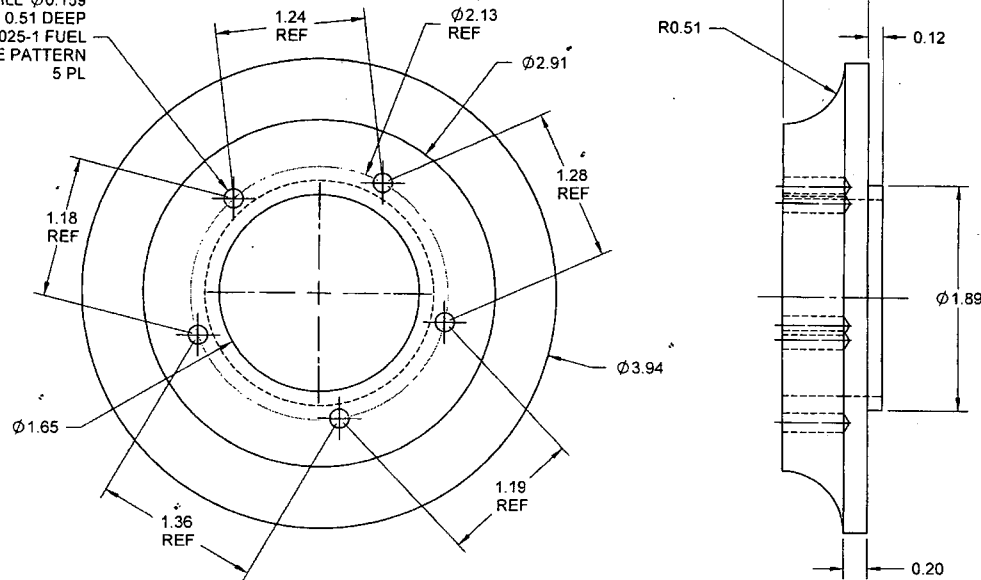
DART AEROSPACE
PART NUMBER

D4001-1

JOHN CAMERON AVIATION
PART NUMBER

JCA-M47-1-08

DRILL $\phi 0.159$
TAP 10-32 UNF X 0.51 DEEP
SPACED TO MATCH D4025-1 FUEL
SENDER UNIT HOLE PATTERN
5 PL



D4001-1 FITTING

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC M6061T6R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.47 lbs

RELEASED
2010-05-05
W

A		NEW ISSUE		BY	DATE
REV.		DESCRIPTION			
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN					
CHECKED		DRAWING NO.		REV. A	
MFG. APPR.		D4001			SHEET 1 OF 2
APPROVED		TITLE			SCALE
DE APPR.		FITTING			NTS
DATE		10.02.05	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

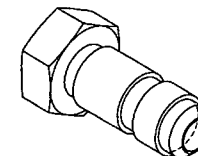
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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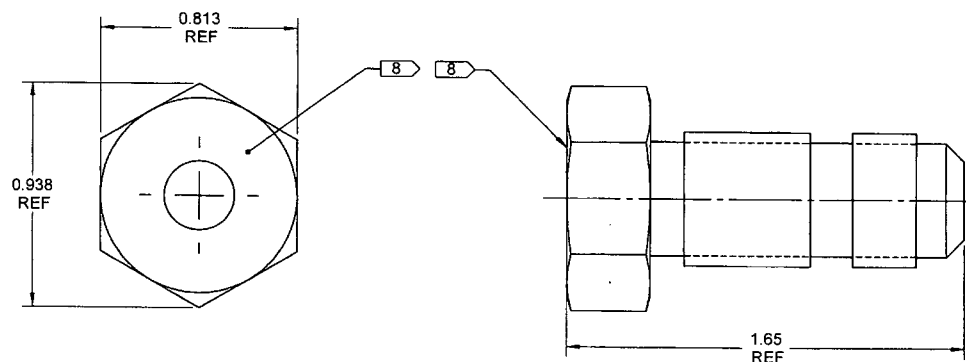
NOTE: Date & initial all entries

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4001-3	JCA-M47-2-28 (AN832-6D-JCA)

AN832-6D
BEFORE MODIFICATION
REF



u/c 46840



D4001-3 FITTING

RELEASED
2010-05-05

NOTES:

- 1) MATERIAL: MADE FROM AN832-6D
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4001-3" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.04 lbs
- 8) BRUSH ALODINE MACHINED SURFACE

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4001	REV. A
MFG. APPR.		TITLE FITTING	SHEET 2 OF 2
APPROVED		SCALE	NTS
DE APPR.		DATE 10.02.05	
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	66840
Description:		Part Number:	
Inspection Dwg:		Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article

Prototype

[illegible]

Measured by:	SK
Date:	11/03/07

Audited by:	<i>ML</i>
Date:	<i>11/03/68</i>

Prototype Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	